Work Order ID 90056 *90056*

September-13-12 11:21:39 AM

Item ID: D412-791-045 **Accept** *N900040100* **Setup Start** *NS1* **Stop** *NS2*

Revision ID:

Item Name: Exit Illumination Assembly

Start Date: 9/13/12 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 10/12/12 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1* **Stop** *NR2*

Approvals: **Process Plan:** MLJ **Date:** 12-09-14 **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
IIN-D412-791	B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100*		0.00	DAS 15 9-89						
DC Document Control	**Memo** Photocopy bluefile & type labels per PPP 412-791-045	0.00	12 12 05 CHG001			HJ Car MLJ 12-12-4			12/12/3 DAS 20 9-89
110 *110*	Pick Kit	0.00							
Packaging Packaging	**Memo**	0.00				12/12/3			1
120 *120*	QC4- 100% Inspect kits for completeness	0.00	DAS 15 9-89						
QC Quality Control	**Memo**	0.00	12 12 03			1			

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Work Order: ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Part No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
NCR No. ____________	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped.	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 90056 *90056*

September-13-12 11:21:39 AM

Item ID: D412-791-045 **Accept** *N900040100* **Setup Start** *NS1* **Stop** *NS2*

Revision ID:

Item Name: Exit Illumination Assembly

Start Date: 9/13/12 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 10/12/12 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1* **Stop** *NR2*

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging		0.00				20 9-85	Sh		12/12/05
Packaging	**Memo** Identify and pack for shipping as per PPP D412-791-045 Location: PG 031A PPP Rev:________	0.00							
140 *140* QC	QC21- Final Inspection - Work Order Release	0.00							12/12/05
Quality Control	**Memo**	0.00							

MCJ 12-12-05

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Work Order: ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Part No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
NCR No. ____________	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ____________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

September-13-12 11:21:39 AM

Work Order ID: 90056

Parent Item: D412-791-045

Parent Item Name: Exit Illumination Assembly

Start Date: 9/13/12 **Required Date:** 10/12/12

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3950-1 RIVET		Manufactured	No				Each	126.0000		90			

Location		Loc Qty	Loc Code
ST074		126	
	78225	126	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3937-041 Luminescent Strip Assembly		Manufactured	No			110	Each	36.0000	16	16			

Location		Loc Qty	Loc Code
ST		-46	
ST072		46	
ST074		36	
	78224	3	
	89647	33	

DQA: ________ Date: ______________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ______	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ______	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Equip/Tooling ☐									
Operator ☐									
Material ☐									
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Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
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☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
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☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

7.0 PARTS LIST

QTY -011	QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
X						D412-791-011	SAFETY ENHANCEMENT KITS COMPLETE
1	X					D412-791-041	FLASHLIGHT KIT
1		X				D412-791-043	MAPBOX KIT
1			X			D412-791-045	EXIT ILLUMINATION KIT
1				X		D412-791-047	PITOT HEAT MONITORING KIT
1					X	D412-791-049	STANDBY ATTITUDE BATTERY MONITORING KIT
	2					D3921-1	FLASHLIGHT
	4					D3922-1	CLIP
	2					D3923-1	ANGLE
	4					D3924-1	SHIM
	8					MS20426AD3-6	RIVETS
	6					MS20470AD4-5	RIVET
	4					MS21059-L3	ANCHOR NUT
	4					MS35207-264	SCREW
		1				D3936-041	MAPBOX
		4				MS35207-244	SCREW
			16			D3937-041	PHOTOLUMINESCENT STRIPS
			90			D3950-1	RIVET (INCLUDES 10 EXTRA)
				1		18-200	CONNECTOR
				6		1N4007	DIODE
				3		80-004-2-6	POTTED INSERTS
				2		D3896-1	RELAY
				1		D3897-1	ANGLE
				1		LED-50-17-BG-E0705	ANNUNCIATOR
				1		M12883/45-01	RELAY BASE
				1		M81714/16-3	TERMINAL BLOCKS TRACK
				2		M81714/2-DC1	TERMINAL BLOCKS
				1		M81714/2-DD2	TERMINAL BLOCKS